

5/20

DART AEROSPACE LTD		Work Order:	23099
Description: Frame Weldment		Part Number:	D3330-041
Dwg: D3330 Rev. <i>AB</i> <i>05-01-13</i>		Qty:	1
PAGE 1 RF 05.01.17		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler	<i>[Signature]</i>	05.04.25	1																																																
2	MFA	Assemble and Weld as per Dwg D3330 using D3330-041T1 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr><td>1</td><td>D3330-1</td><td>Panel</td><td>B22153</td></tr> <tr><td>1</td><td>D3330-2</td><td>Panel</td><td>B22153</td></tr> <tr><td>1</td><td>D3330-3</td><td>Panel</td><td>B22153</td></tr> <tr><td>1</td><td>D3330-5</td><td>Panel</td><td>B22153</td></tr> <tr><td>1</td><td>D3330-7</td><td>Panel</td><td>B22153</td></tr> <tr><td>1</td><td>D3330-9</td><td>Panel</td><td>B22153</td></tr> <tr><td>1</td><td>D3330-11</td><td>Long Pin Bracket</td><td></td></tr> <tr><td>1</td><td>D3330-13</td><td>Short Pin Bracket</td><td></td></tr> <tr><td>1</td><td>D3330-15</td><td>Handle</td><td></td></tr> <tr><td>1</td><td>D3330-17</td><td>Handle Socket</td><td></td></tr> <tr><td>1</td><td>D3330-19</td><td>Handle Rim</td><td></td></tr> </tbody> </table> Identify as D3330-041 <i>X2 scarp</i> <i>X1 scarp</i>	Qty	Part Number	Description	Batch	1	D3330-1	Panel	B22153	1	D3330-2	Panel	B22153	1	D3330-3	Panel	B22153	1	D3330-5	Panel	B22153	1	D3330-7	Panel	B22153	1	D3330-9	Panel	B22153	1	D3330-11	Long Pin Bracket		1	D3330-13	Short Pin Bracket		1	D3330-15	Handle		1	D3330-17	Handle Socket		1	D3330-19	Handle Rim				
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1	D3330-17	Handle Socket																																																			
1	D3330-19	Handle Rim																																																			
3	QC5	Inspect work to Step 2																																																			
4	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3																																																			
5	QC3	Inspect Powder Coat																																																			
6	ST	Identify and Stock																																																			
7	AC	Cost/Part: <i>148.13</i>																																																			
8	DC	Close W/O Inspect Level 21	<i>S4C</i>	05-05-25																																																	

Rev	Date	Change	Revised By	Approved
A	05.01.13	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
05.01.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		D3330-1 P					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-20	26.	D3330-1 Bent wrong way						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

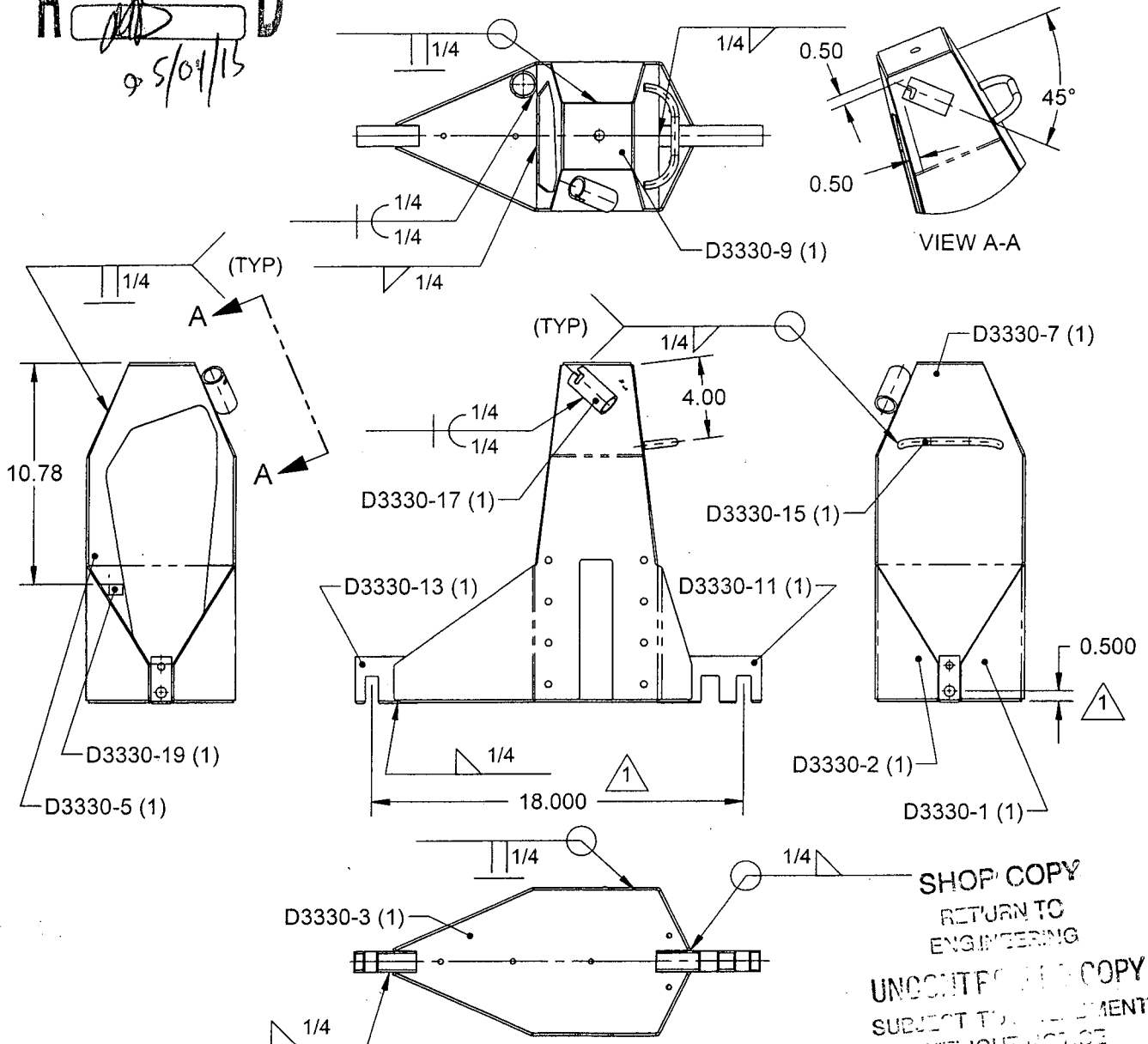
QA: N/C Closed: _____ Date: _____



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED 13	DRAWING NO. D3330	REV. B SHEET 1 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:8
A	04.12.16	NEW ISSUE	
B	05.02.26	REDESIGN	

RELEASED

95/01/13



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 21, 2005
12:52 pm

Work Order No : 0023099
Project Name : D3330-041
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3330-041
Description : Frame Weldment
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 04-21-05
Est Finish Date : 05-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

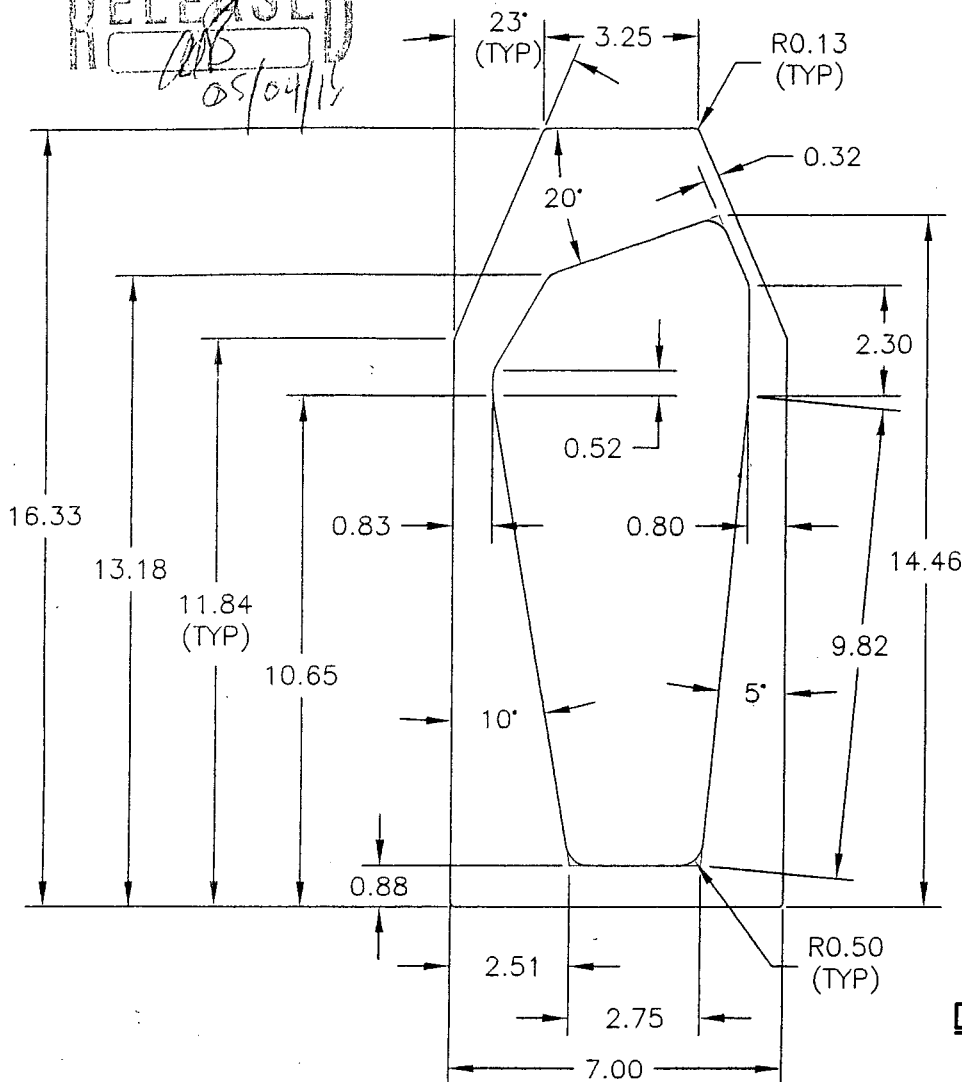
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

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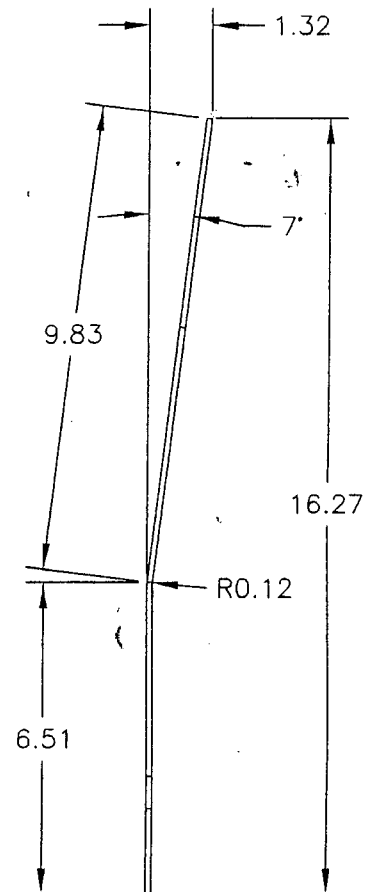


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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:4

RELEASED
05/04/11



FLAT PATTERN



D3330-5 BEND DETAIL

REFERENCE ONLY

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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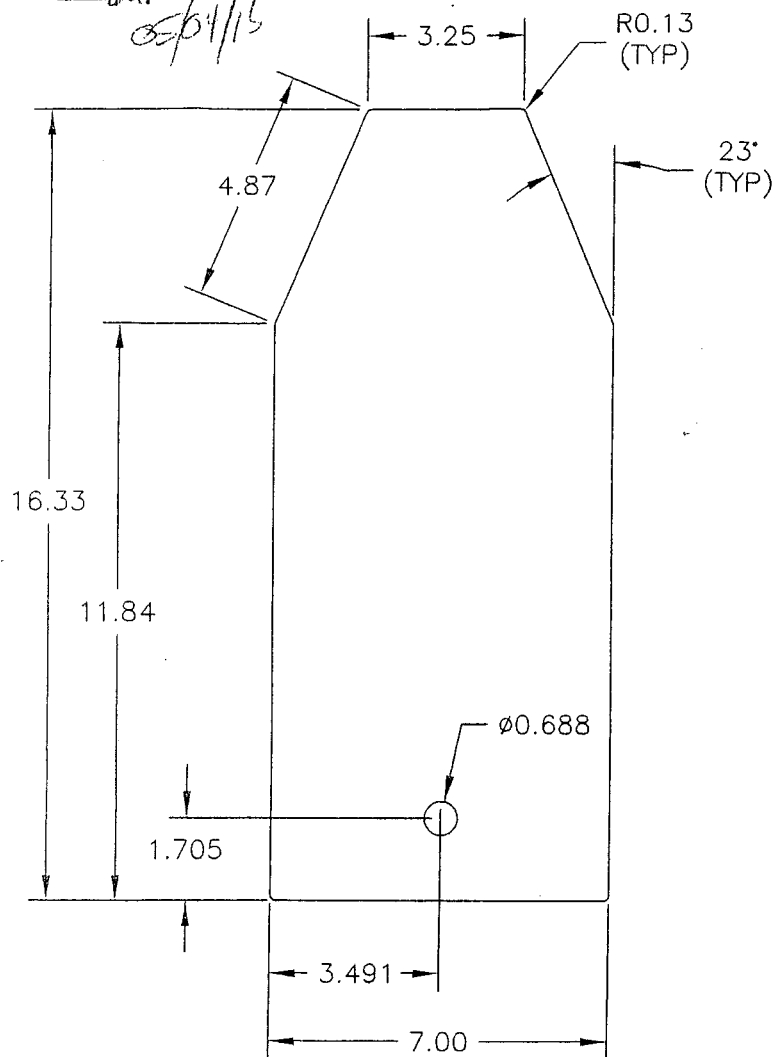
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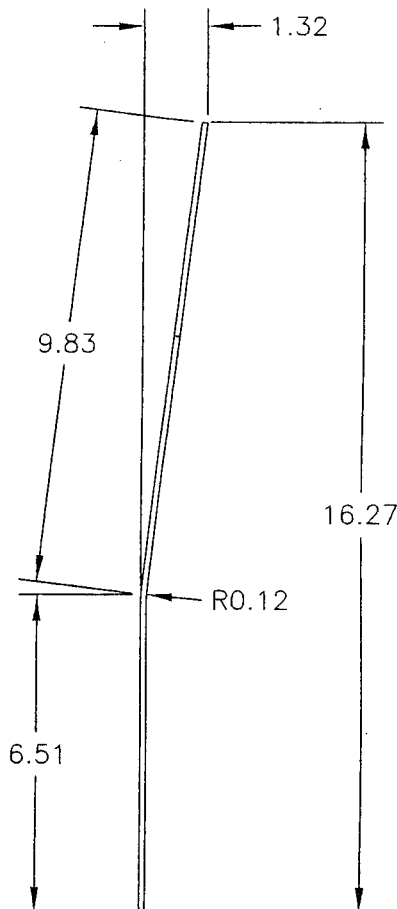


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DATE 05.02.26		TITLE FRAME ASSEMBLY	SCALE 1:4

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[Signature]
05/11/15



FLAT PATTERN



D3330-7 BEND DETAIL

REFERENCE ONLY

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

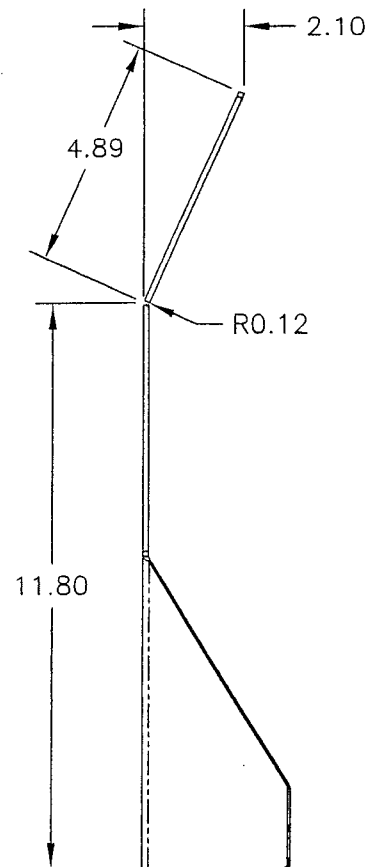
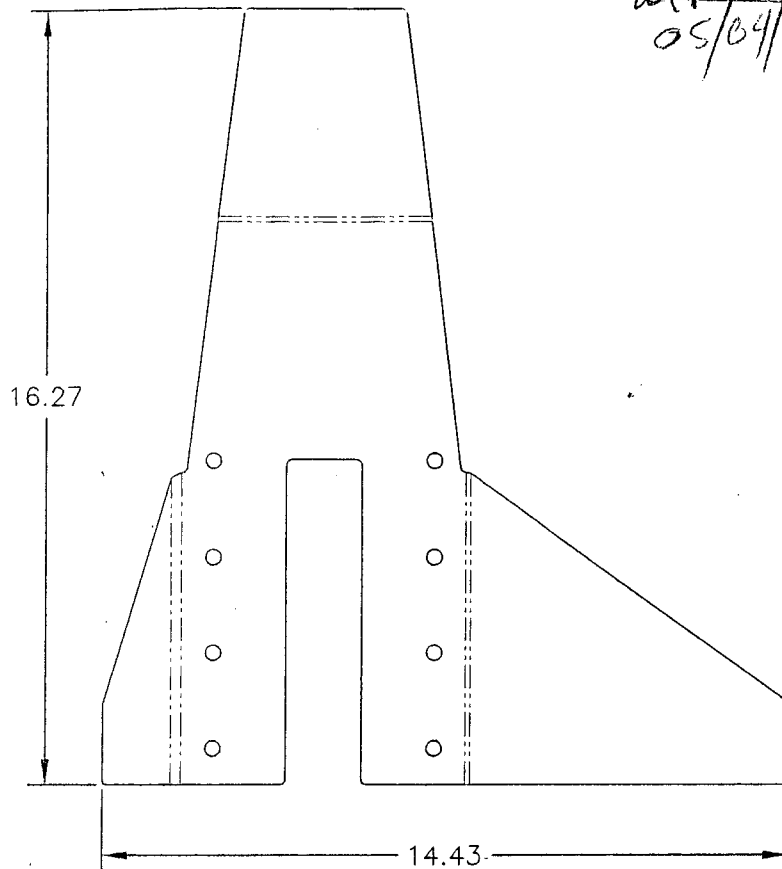
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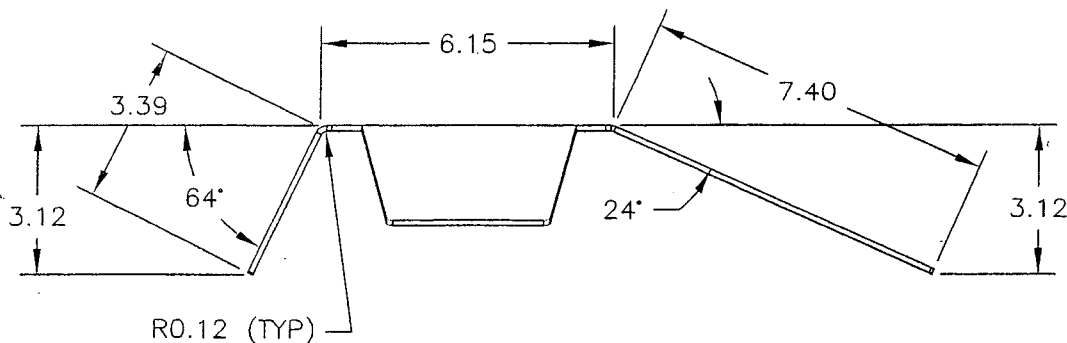
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

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05/04/15



REFERENCE ONLY



D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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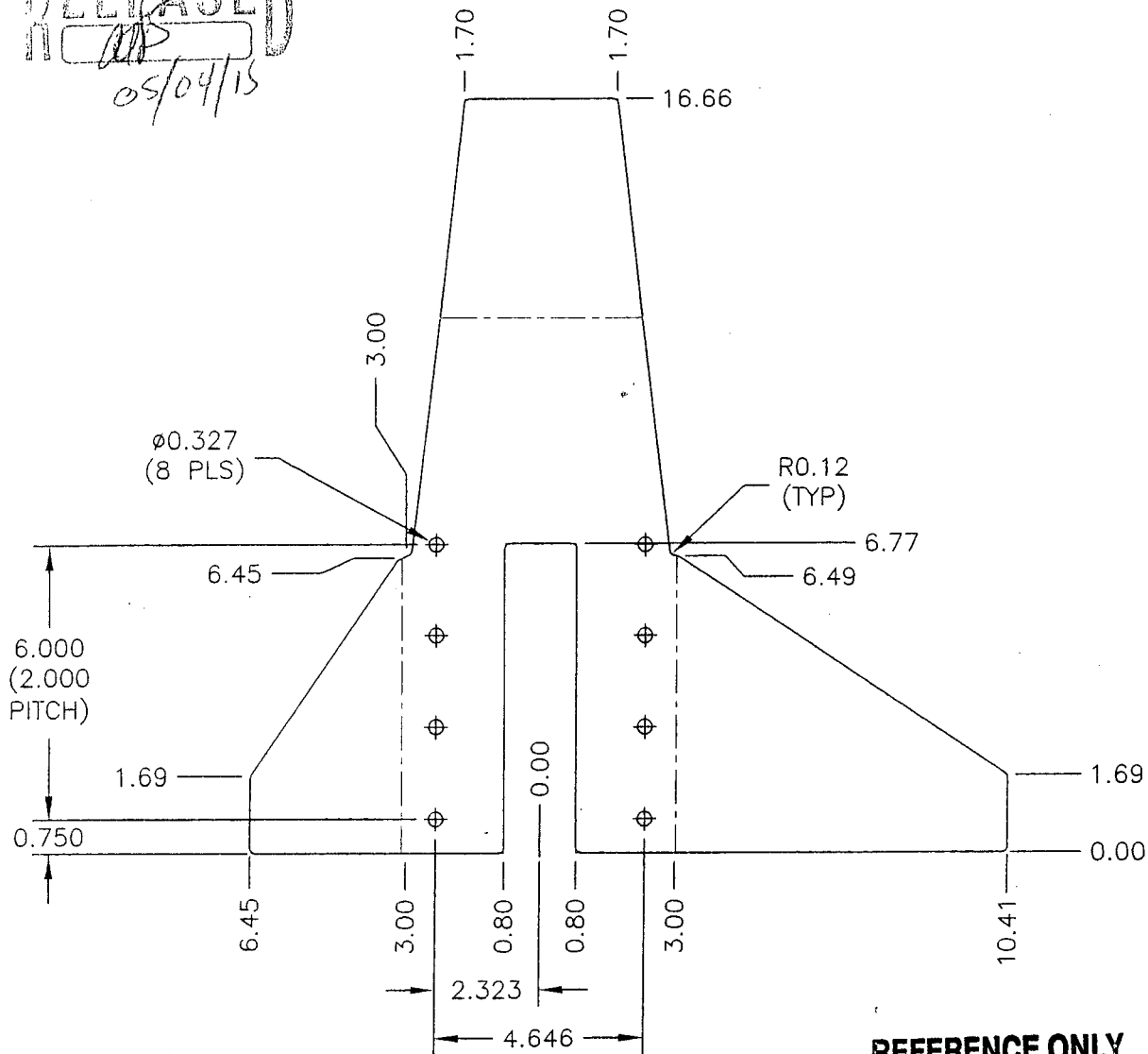
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

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[Signature]
05/04/15



REFERENCE ONLY

D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

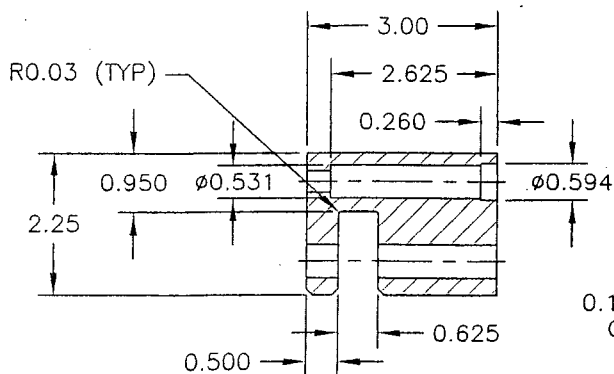
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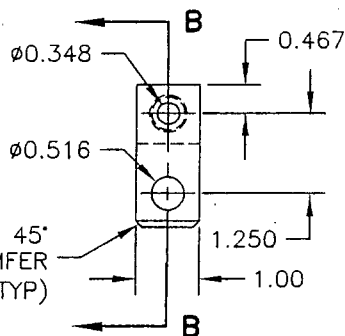


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CHECKED <i>ag</i>	APPROVED <i>ag</i>	DRAWING NO. D3330	REV. B SHEET 9 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3

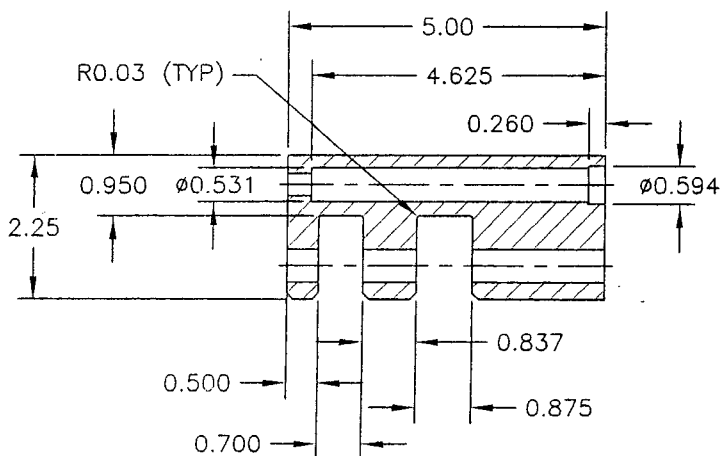
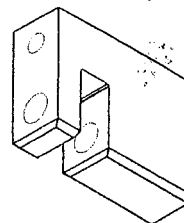


SECTION B-B

D3330-13 SHORT PIN BRACKET

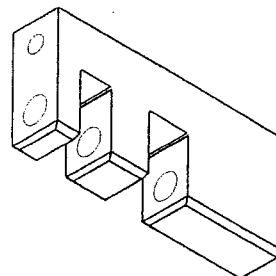
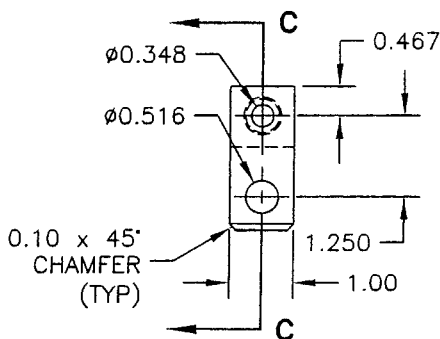


RELEASED
ag
05/04/15.



SECTION C-C

D3330-11 LONG PIN BRACKET



REFERENCE ONLY

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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